

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-006251**Date Inspected:** 15-Apr-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Zhao Chen Sun**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG components**Summary of Items Observed:**

On the date CALTRANS OSM Quality Assurance (QA) Inspector, Dilip Chakrabarti was present during the times noted above for observations relative to the work being performed.

Bay# 6-OBG Assembly

This QA Inspector randomly observed the following work in progress:

Magnetic Particle Testing:

For Green Tag:

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL-6028 MT report on this date.

The member and the weld designations are as follows:

Sl # Section # Weld # Green Tag # Location

1. SP 206-009 006,007,008 006524 8A
2. SP 637-001 017,019,021,023 006525 11 CE
3. SP 741-001 030 006528 11 BW
4. DP 203-009 010,011,012,013,014 006351 8 A
5. DP 202-009 010,011,012,013,014 006352 8 A
6. SP 598-001 030 006536 11 DE
7. SP 595-001 030 006534 11 BE

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- 8. SP 784-001 028 006535 11 DW
- 9. SP 744-001 041 006532 11 DW
- 10. SP 638-001 017 006526 11 DE
- 11. SP 635-001 028 006529 11 BE
- 12. SP 558-001 014 006531 11 DE
- 13. SP 555-001 014 006530 11 BE
- 14. SP 506-001 001 006533 11 DW
- 15. SP 503-001 014 006527 11 BW
- 16. SP 781-001 028 006537 11 BW
- 17. NSD1 DPSA3-4 11,12 005822 NA
- 18. WSD1 DPSA3-18 9,10 005842 NA
- 19. SSD1 DPSA3-1 B/B1,2,3,4,9,10,13,14 NA NA
- 20. SSD1 DPSA3-1 B/B21,22,23,24,25,26 NA NA
- 21. ESD1 DPSA3-17 B/B1,2,3,8,9,10,13,14 NA NA
- 22. ESD1 DPSA3-17 B/B21,22,23,24,25,26 NA NA
- 23. NSD1 DPSA3-8 8 NA NA

Bay# 6-Tower Assembly

This QA Inspector randomly observed the following work in progress:

FCAW Process:

Welding of weld joints# 1,43 located on PCMK WD1 CBSA3-1-8. Welder is identified as 209554. ZPMC QC is identified as Zhang Bao Bo. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2332-TC-P4-F-1.

Welding of weld joints# 4,13 located on PCMK WD1 CBSA3-1-8. Welder is identified as 019006. ZPMC QC is identified as Zhang Bao Bo. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2332-TC-P4-F-1.

Welding of weld joints# 45 located on PCMK WD1 CBSA3-1-8. Welder is identified as 058174. ZPMC QC is identified as Zhang Bao Bo. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2332-TC-P4-F-1.

Welding of weld joints# 21 located on PCMK WD1 CBSA3-1-8. Welder is identified as 053609. ZPMC QC is identified as Zhang Bao Bo. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2332-TC-P4-F-1.

Bay # 7-OBG Assembly:

This QA Inspector randomly observed the following work in progress:

FCAW Process:

Welding of weld joints# 1&2 located on PCMK SP 682-001. Welder is identified as 053742. ZPMC QC is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2132- 3.

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Welding of weld joints# 5&6 located on PCMK SP 682-001. Welder is identified as 051246. ZPMC QC is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2132- 3.

Welding of weld joints# 9&10 located on PCMK SP 682-001. Welder is identified as 202841. ZPMC QC is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2132- 3.

Unless otherwise noted, all work observed on this date appeared to be generally comply with applicable contract document

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Chakrabarti,Dilip Kumar	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
